

Order # 16536 [Dart Hawkesbury] Job Sheet - Lajeunesse, Marie



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Canada

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10/15

D350-591-311
Job Sheet 198860



Part No: D350-591-311

Job Qty: 10 pcs

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/7/19

Job Tracking No:

Due Date: 11/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in born DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	10 pcs	11/5/19		0.00	9.91	Large Fab - 1		SLe
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
120	QC 9	10 pcs	11/5/19		0.00	0.00	QC 9 - 10		DAS 24 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
130	QC 5	10 pcs	11/5/19		0.00	0.00	QC 5 - 10		DAS 24 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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140 Handfinish - 1-1 Chemical-B4B	10 pcs	11/5/19	0.00 1.84	QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 1 - 1 - B4B	8EB19-10-08
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	10 pcs	11/5/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	DAS
				QC 7 - 67	24
				QC 7 - 40	9-89
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
180 Large Fab - Steps - 2 - B4B	10	11/5/19	0.00 9.91	Large Fab - 1 - B4B	

	pcs				Large Fab - 10 - B4B		S	
					Large Fab - 2 - B4B			
					Large Fab - 3 - B4B			
					Large Fab - 4 - B4B			
					Large Fab - 5 - B4B			
					Large Fab - 6 - B4B			
					Large Fab - 7 - B4B			
					Large Fab - 8 - B4B			
					Large Fab - 9 - B4B			
					Large Fab - 11 - B4B (Various)			
190 QC 10	10 pcs	11/5/19	0.00 0.00		QC 10 - 10			
					QC 10 - 18			
					QC 10 - 24	DAS		
					QC 10 - 43	24		
					QC 10 - 50	9-89		
					QC 10 - 58			
					QC 10 - 9			
200 QC 5	10 pcs	11/5/19	0.00 0.00		QC 5 - 10			
					QC 5 - 12			
					QC 5 - 17			
					QC 5 - 18			
					QC 5 - 19			
					QC 5 - 22			
					QC 5 - 24	DAS		
					QC 5 - 3	24		
					QC 5 - 43	9-89		
					QC 5 - 49			
					QC 5 - 51			
					QC 5 - 58			
					QC 5 - 68			
					QC 5 - 9			
					QC 5 - 50			
					QC 5 - 30			
					QC 5 - 40			
					QC 5 - 61			
					QC 5 - 81			
210 Handfinish - 1-2- Chemical- B4B	10 pcs	11/5/19	0.00 1.84		Handfinish - 1 - 1 - B4B			
					Handfinish - 1 - 2 - B4B			
					Handfinish - 1 - 3 - B4B		★ OCT 11 2019	
					Handfinish - 1 - 4 - B4B			
					Handfinish - 1 - 5 - B4B			
					Handfinish - 1 - 6 - B4B			
					Handfinish - 1 - 7 - B4B			
					Handfinish - 1 - 8 - B4B			
					Handfinish - 1 - 9 - B4B			
					Handfinish - 1 - 10 - B4B			
					Handfinish - 1 - 11 - B4B			
					Handfinish - 1 - 12 - B4B			
					Handfinish - 1 - 13 - B4B			
					Handfinish - 1 - 14 - B4B			
					Handfinish - 1 - 15 - B4B			
					Handfinish - 1 - 16 - B4B			
					Handfinish - 1 - 17 - B4B			
					Handfinish - 1 - 18 - B4B			
					Handfinish - 1 - 19 - B4B			
					Handfinish - 1 - 20 - B4B			
					Handfinish - 1 - 21 - B4B			
					Handfinish - 1 - 22 - B4B			
		</						

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220 Powdercoat - 1 White GI(A)- B4B	10 pcs	11/5/19	0.00 2.90	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BL 19-10-15
				Powdercoat - 4 - B4B	
230 Handfinish - 3-1- WingWalk- B4B	10 pcs	11/5/19	0.00 1.84	Handfinish - 3 - 1 - B4B	BL 19-10-16
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
240 QC 3	10 pcs	11/5/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	OCT 17 2019
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
250 Packaging 1-1 - Pick Kit - B4B	10 pcs	11/5/19	0.00 0.00	Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	P< OCT 18 2019
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	

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260 QC 4	10 pcs	11/5/19	0.00 0.00	Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
				QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	DAS 78
				QC 4 - 75	9-89
					OCT 21 2019
270 Packaging 3-1 - Stock - B4B	10 pcs	11/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	DAS 78
				Packaging 3 - 25 - B4B	9-89
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	DAS 21
				Packaging 3 - 36 - B4B	9-39
					OCT 21 2019
275 DC - 1 - B4B	10 pcs	11/5/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
280 QC 21 - FG	10 pcs	11/5/19	0.00 0.00	QC 21 - FG - 21	DAS 21
				QC 21 - FG - 70	9-39
				QC 21 - FG - 53	

Part Op 110 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig
 Descriptions: DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush
 120 - (QC9- Inspect visual per QSI004- Fusion Welds) MI39012
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 180 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet
 out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate
 as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.
 190 - (QC10- Inspect visual per QSI004- ground welds)
 200 - (QC5- Inspect part completeness to step on W/O)
 210 - (Chemical Conversion Coat per QSI005 4.1)
 220 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 2:05 OVEN TEMPERATURE: 300°
 FINISH TIME: 2:55 MI193459
 230 - (Wing Walk as per dwg QSI005 4.4 Batch _____)
 240 - (QC3- Inspect Part Finish)
 250 - (Pick Kit)
 260 - (QC4- 100% Inspect kits for completeness)
 270 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPPD350-591-311 Location :
 FG109
 275 - (Document Control) Photocopy bluefile and type labels as per PPP D350-591-311 CHG001
 280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	5198236
D3219-1	Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	5207455
D3272-1	Step	10 pcs (1 ea)	110-Large Fab - Steps - 1	5217273
D3065-041	Step Leg Assembly	10 pcs (1 ea)	180-Large Fab - Steps - 2 - B4B	5198132
D3066-1	Spacer	20 pcs (2 ea)	180-Large Fab - Steps - 2 - B4B	5198132
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab - Steps - 2 - B4B	5207585
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5158557
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	5196190
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5207521
D2230-3	Mounting Lug	40 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5167173
D2618	Bushing	20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5213123
D2856-400-720	Abrasion Strip 4" X 7.20"	20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5197397
D3235-1	Mounting Lug	20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5221605
D3278-041	Support Assembly	10 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5211533
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5211467
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	5208332
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5201031
NAS1149D0363	Washer	40 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	518019
NAS1149D0463	Washer	160 Ea (16 ea)	250-Packaging 1-1 - Pick Kit - B4B	
NAS1149D0563	Washer	40 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	

110# 12168
 180# 012346

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D3067-1	20	203	0
	D3219-1	20	95	0
	D3272-1	10	10	0
180-Large Fab - Steps - 2 - B4B	D3065-041	10	23	0
	D3066-1	20	257	0
	MS20600-AD4W4	160	1,408	0
250-Packaging 1-1 - Pick Kit - B4B	AN3-35A	20	324	0
	AN4-13A	80	1,260	0
	AN5-36A	20	219	0
	D2230-3	40	648	0
	D2618	20	208	0
	D2856-400-720	20	24	0
	D3235-1	20	287	0
	D3278-041	10	10	0
	MS21042L3	20	685	0
	MS21042L4	80	3,035	0
	MS21042L5	20	387	0
	NAS1149D0363J	40	1,694	0
	NAS1149D0463J	160	4,174	0
	NAS1149D0563J	40	2,029	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ Machining ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ Large Fab ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ Engineering ☐ ☐ ☐ Water Jet ☐ ☐ ☐ Supplier ☐ ☐ ☐ Quality ☐ ☐ ☐		MRB (QS1042) ☐ ☐ ☐																									
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS1042) ☐ ☐ ☐																									
Description Work Order Deviation				Disposition																											
Root Cause Operator ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ Material ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ Human Factors ☐ ☐ ☐				FAULT CATEGORY																											
				<table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>				Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread
Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																												
Bending	Misaligned/off center	Folio/Program	Outside Tolerance																												
Crushing	BOM/Route	Grain Direction	Drawing																												
Cracks	Broken/Damage/Defect	Weld	Finish																												
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing																												
Marks/Chatter	Drill Holes	Out of Sequence	Misread																												
Mislabeled	Fit/Function	Off-set/Set-up																													
Other/Details: _____				Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____																											

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step - High Skid, LH
	X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step - High Skid, RH
		X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step - Low Skid, LH
			X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step - Low Skid, RH
				X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step - High Skid, LH
					X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step - High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	2	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4	4		D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4	4		AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.